



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3490-1

Job Sheet 171430



Part No: D3490-1

Job Qty: ~~80~~ **84**

Part Name: Cross Bolt Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 2/1/18

Job Tracking No:

Due Date: 2/12/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 06-03-03 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	80 Ea		2/10/18	0.00	0.00	Start Up Machining-2		JB
100	Hardinge	80 pcs		2/12/18	0.00	6.50	Hardinge		
120	QC	80 pcs		2/12/18	0.00	0.00	QC8		F.A. B. DAS G
130	Packaging	80 pcs		2/12/18	0.00	0.00	Packaging3-1		FEB 06 2018 WK 36
140	QC21-SA	80 Ea		2/12/18	0.00	0.00	QC21		9-89

Part Op 100 - 1-TURN AS PER FOLIO FA628 & DWG D3490

Descriptions: 130 - CLEAN CROSSBOLT SPACER WITH ALUMINUM CLEANER

DAS
21
9-89

FEB 26 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.500W.049	6061-T6 Round Tube .500 X.049W	21.2800 ft (.266 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.500W.049	21	70	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crossbolt Spacer	0.500inches	+ 0.006 - 0.001	0.506 0.499	
2	Crossbolt Spacer	0.049inches ± 0.010		0.059 0.039	
3	Crossbolt Spacer	0.402inches	+ 0.006 - 0.001	0.408 0.401	
4	Crossbolt Spacer	3.085inches	+ 0.030 - 0.000	3.115 3.085	
5	Crossbolt Spacer	0.050inches ± 0.010		0.060 0.040	
6	Crossbolt Spacer	45Degrees ± 0		45 45	

Plex 2/1/18 9:47 AM Dart.Gagnon.Michelle

DART
AEROSPACE
S039269

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Cross Bolt Spacer

PART NO: D3490-1

Original Serial #: S039269

Revision:

Operation:

Change No:

Start up Operation

02/05/18

Job No: 171430

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

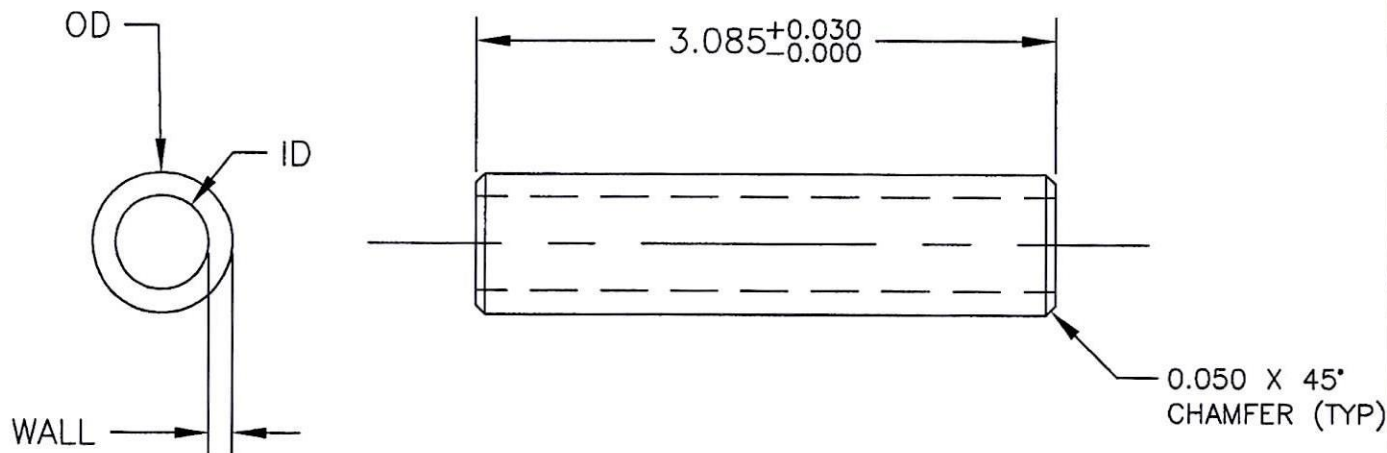
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FEB 01 2018

RELEASED
do-02-07

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